

Work Order ID 81377

Wednesday, March 14, 2012 10:29:04 AM

81377

April 2nd

Page 1

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, 350
 Start Date: 3/14/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *mc* Date: *12-03-14* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: *M115778* 0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

12-03-22

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

pl 12-03-27

IX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 3/14/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/30/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

Insp. Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

1XØ M-12/03/27

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130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: START TIME: 8h05 OVEN TEMPERATURE: 400°F FINISH TIME: 8h35 ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				1	2	20	12/03/28
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			BR 12.3.28

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150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	Pick Kit								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: D430-C011	0.00							
170									
Packaging	Memo	0.00							
Packaging									

1 BR 12.3.28.

5.2/03/28

81372

1 BR 12.3.28.

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180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

012-03-28

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	29.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		29							
				69739		1							
				70766		2							
				77045		1							
				77523		25							
✓ D3913-1 Rib		Manufactured	No			100	Each	1.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		1							
				78039		1							
✓ D3913-15 Wide Handle Plate		Manufactured	No			100	Each	1.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		1							
				78321		1							
✓ D3913-3 Rib		Manufactured	No			100	Each	5.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		5							
				69160		1							
				78287		4							
✓ D3913-7 Rib		Manufactured	No			100	Each	6.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				79416		6							

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-9 Manufactured No 100 Each 2.0000
Hinge Rib

Location	Loc Qty	Loc Code
WA006	2	
70138	1	
79876	1	

1 81441 → 1x *SY* 12.03.21

✓ D3916-041 Manufactured No 100 Each 2.0000
Rib Assembly

Location	Loc Qty	Loc Code
WA006	2	
69161	2	

2 379909 → 2x *SY* 12.03.21

✓ D3916-5 Manufactured No 100 Each 8.0000
Light Rib

Location	Loc Qty	Loc Code
WA006	8	
79908	8	

3 381434 → 1x *SY* 12.03.21

✓ D4016-1 Manufactured No 100 Each 23.0000
Hinge Half, Base

Location	Loc Qty	Loc Code
WA005	23	
75281	4	
79413	19	

2x
3 *SY* 12.03.21

✓ D4017-7 Manufactured No 100 Each 2.0000
Rib

Location	Loc Qty	Loc Code
WA005	2	
69730	1	
74682	1	

3x
1 381176 → 1x *SY* 12.03.21

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-9 Rib Manufactured No 100 Each 8.0000

Location	Loc Qty	Loc Code
WA	2	
79415	2	
WA006	6	
70341	2	
73531	4	

2
B81515 → 2x
12.03.21

✓ D4020-11 End Mesh, Basket Manufactured No 100 Each 10.0000

Location	Loc Qty	Loc Code
WA035	10	
69648	2	
78693	8	

2 2
12.03.21

✓ D4021-1 Handle Plate Manufactured No 100 Each 8.0000

Location	Loc Qty	Loc Code
WA	8	
69518	0	
74316	0	
74946	0	
79414	8	

2x
3 3
B81443 → 1x
12.03.21

✓ D4034-041 Aft Upper Rib Assembly Manufactured No 100 Each 0.0000

D4034-043 Fwd Upper Rib Assembly Manufactured No 100 Each 3.0000

Location	Loc Qty	Loc Code
WA006	3	
78036	1	
78329	2	

2x
1 1
B81172 → 1x
12.03.21
1x

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Page 4

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

772.5296

33

33

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

772.5294457

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

85.2413116

120917

311.09

AN3-10A

Purchased

No

150

Each

379.0000

6

6

Bolt

Location

Loc Qty

Loc Code

GA

75

119084

75

ST351

304

117795

4

120873

300

AN960JD8

NAS1149DN832J

Purchased

No

150

Each

0.0000

2

2

Washer

D2931

Manufactured

No

150

Each

496.0000

2

2

Bumper

Location

Loc Qty

Loc Code

ST504

496

46064

496

Wednesday, March 14, 2012 10:29:04 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-5
Blanking Plate

Manufactured No

150 Each 7.0000

2 2

Location

Loc Qty

Loc Code

GA

7

73478

7

MS20600-AD4W3

Purchased No

150 Each 1,304.0000

2 2

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1171

111636

36

117505

6

117601

27

118626

602

120308

500

WA018

133

107939

133

MS21042L3

Purchased No

150 Each 3,192.0000

6 121329 2

Nut

Location

Loc Qty

Loc Code

ST300

3192

117441

16

117885

32

118451

5

118927

3

119017

2956

119075

180

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Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

782.0000

12

12/3/12

WASHER

Location

Loc Qty

Loc Code

ST275

782

117735

37

119225

142

120498

200

120910

200

120986

200

17317

3

12

Dart Aerospace Ltd

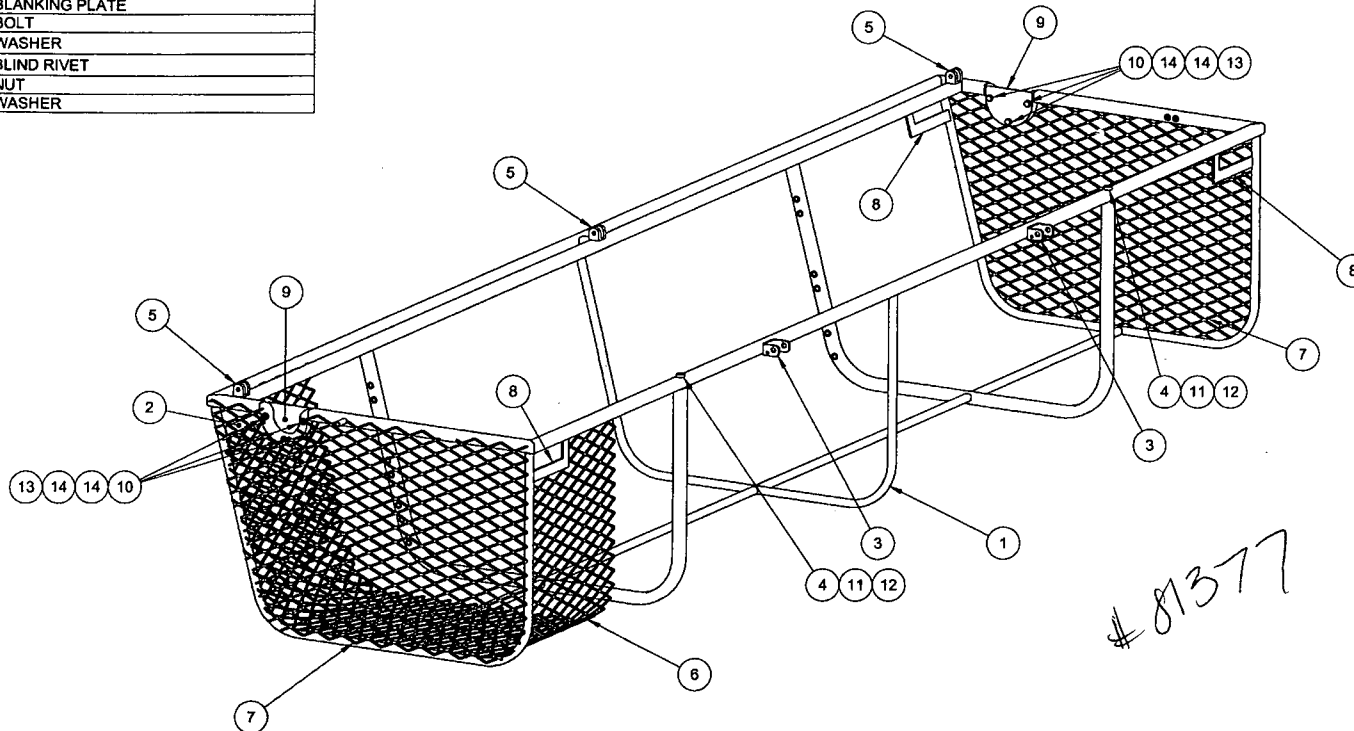
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN980JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
WJP

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. A
TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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Dart Aerospace Ltd

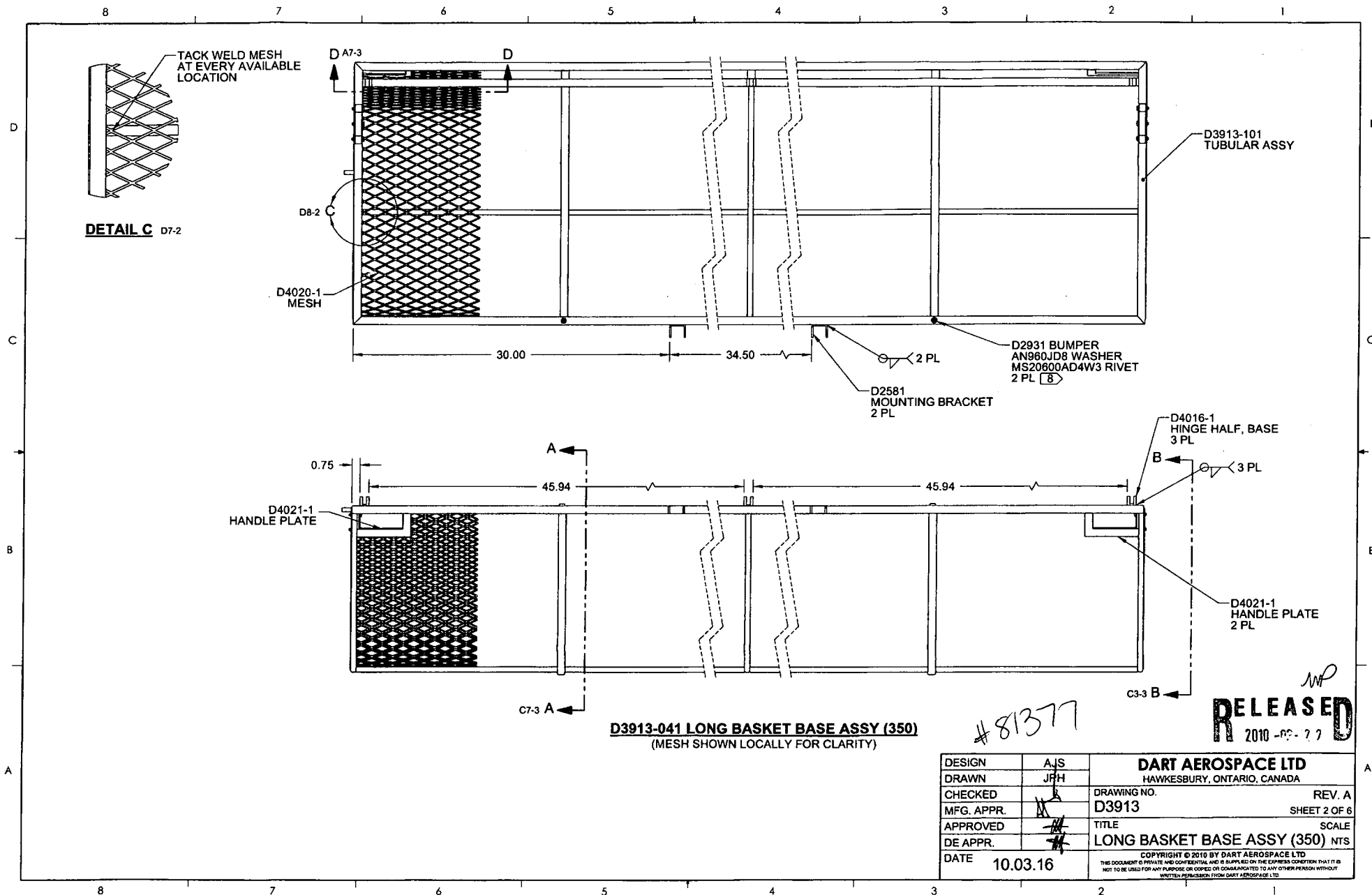
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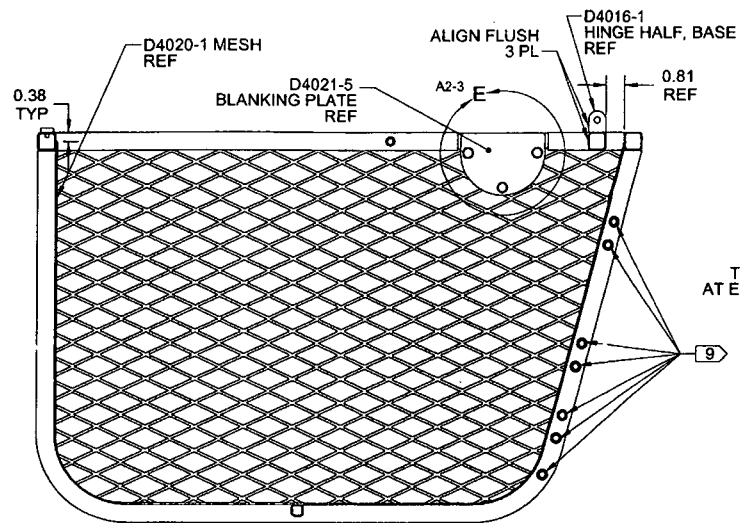
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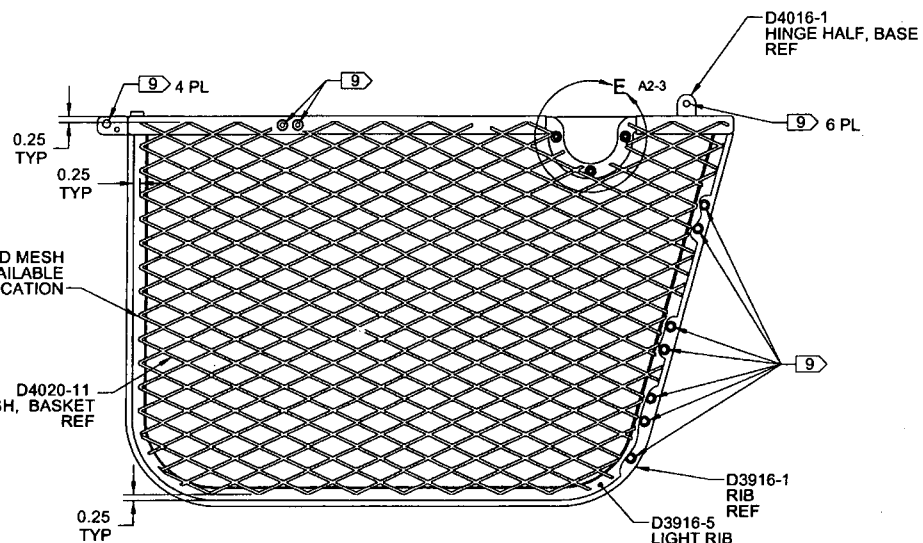
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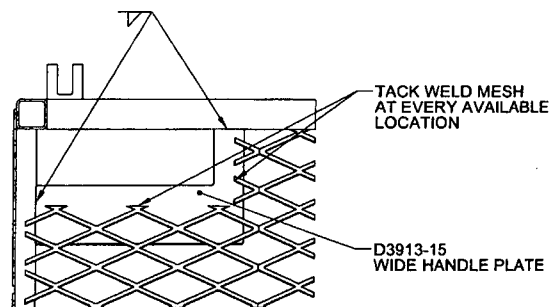
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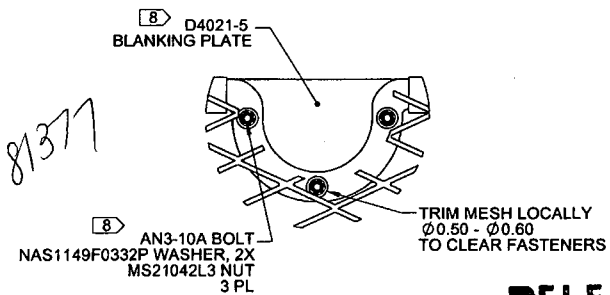
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

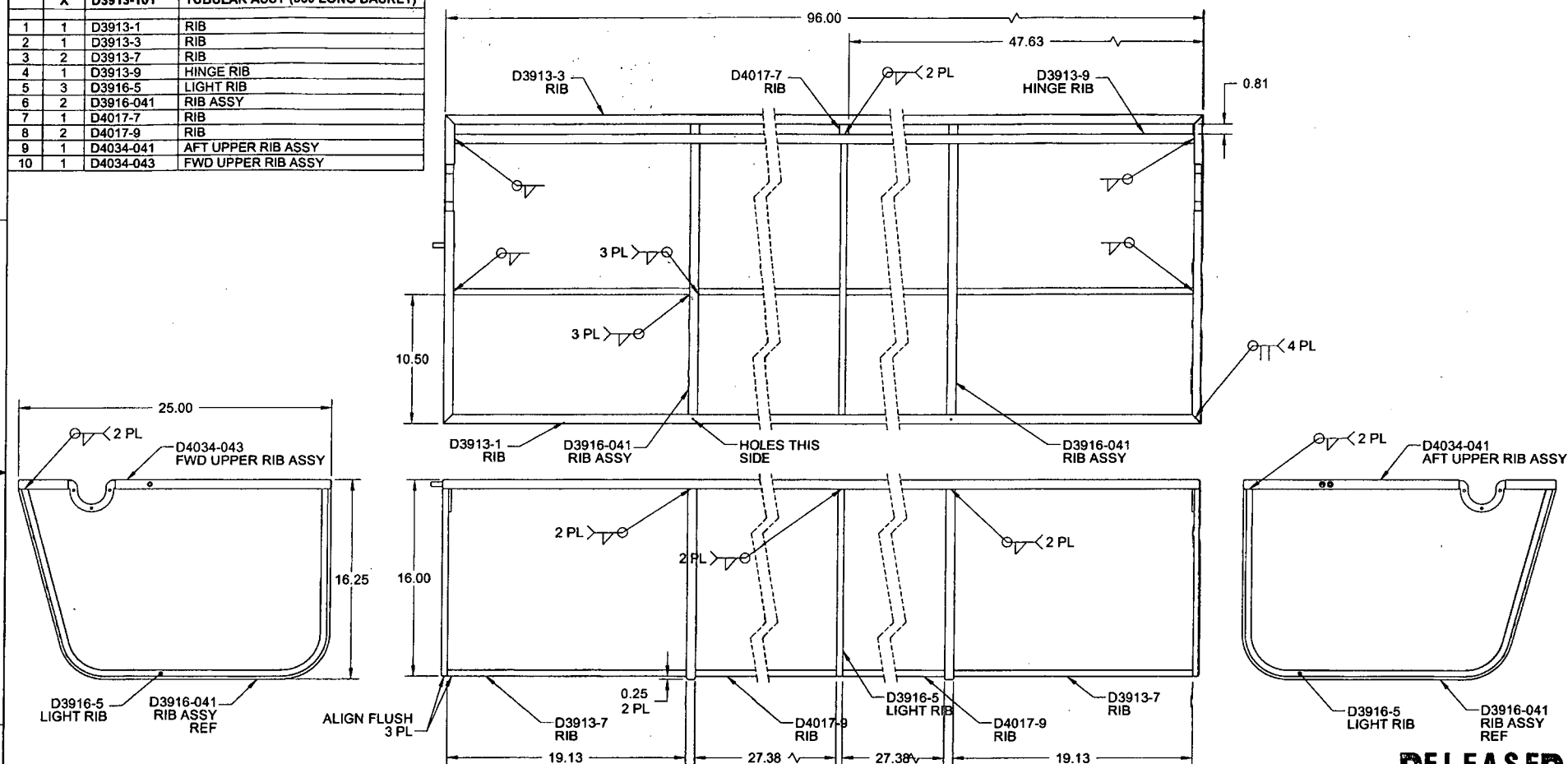
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
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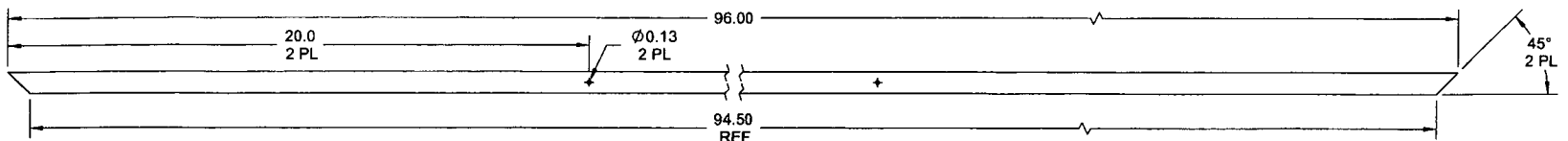
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

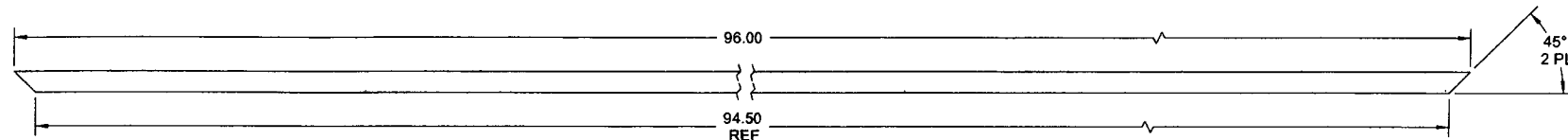
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

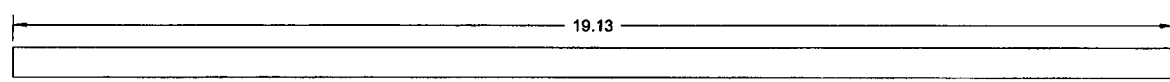
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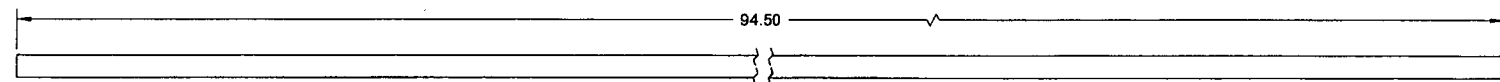
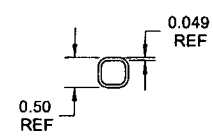
D3913-1 RIB



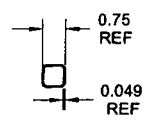
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



- NOTES:**
- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.		D3913	SHEET 5 OF 6
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8 7 6 5 4 3 2 1

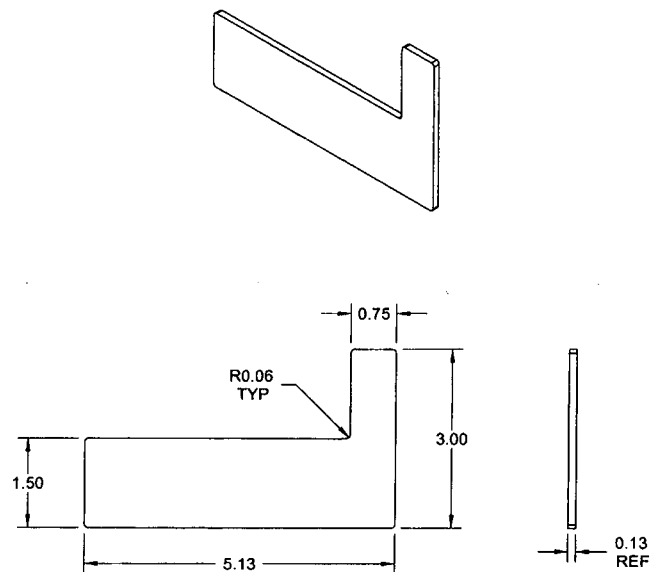
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
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DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries